

Date: Friday, 11/01/2008 10:59:54 AM
 User: Linda Lacelle

Process Sheet

14/01
Split 208-01-15

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	: 36710A - 1			Part Number	: D2278		
Estimate Number	: 10353			Drawing Number	: D2278 REV F		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 11/01/2008	S.O. No.	: N/A	Drawing Revision	: F		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 15/01/2008 Qty: 40 Um: Each		
Previous Run	: 33253B						
Written By							
Checked & Approved By							
Comment	: Est Rev:A New Issue 05-11-07 JLM						
	Est Rev:B Now 6061-T6 06-06-23 JLM						
	Est Rev C New flat pattern 08.01.11 EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet 48
		Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick m5052H32S080 QL (M6061T62S.080) Identify as D2278 Batch: 100947 x08 288569 RB 8-1-14 100742 x 10 = 10.306
2.0	WATER JET	FLOW WATER JET 30
		Comment: FLOW WATER JET 1-Cut as per Dwg D2278 Dwg Rev: F RB 8-1-14 Prog Rev: F 2-Deburr if necessary RB 8-1-14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 100742 x 10 = 10.306 QC2 8-1-14
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK QC8 8-1-14
		Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod. Mgr	Approval QC Inspector
08-01-15	30	- split for a Qty of 8 parts needed on the -2 split - Qty 36 remained on this order.	/	08-01-15	8	08-01-15	08-01-15

Part No: D2278 PAR #: N/A Fault Category: Prod/Fab. Ass. ^{med/Small} NCR: Yes No DQA: D Date: 08/01/17
 QA: N/C Closed: Date: _____

NCR: 35710A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/15	12	44 Parts SCRAP Parts 0.10" too short in width. 8.46 → 8.36" R.C. wrong Program on Memory stick. Human error	/	Clean off memory stick	08-01-15	/	AB 08/01/15	08/01/15
				SCRAP and destroy all 44 PARTS. Replace B/E 100% / 100% 08/01/15	08-01-15	08/01/15		

NOTE: Date & initial all entries

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Drawing Name: STEP LEG

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Seq. #: Machine Or Operation:

Description :

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



BL 08/01/16

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H

08/01/16

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock,
Location: MR

08 - 01 - 16

(30)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/17

Job Completion



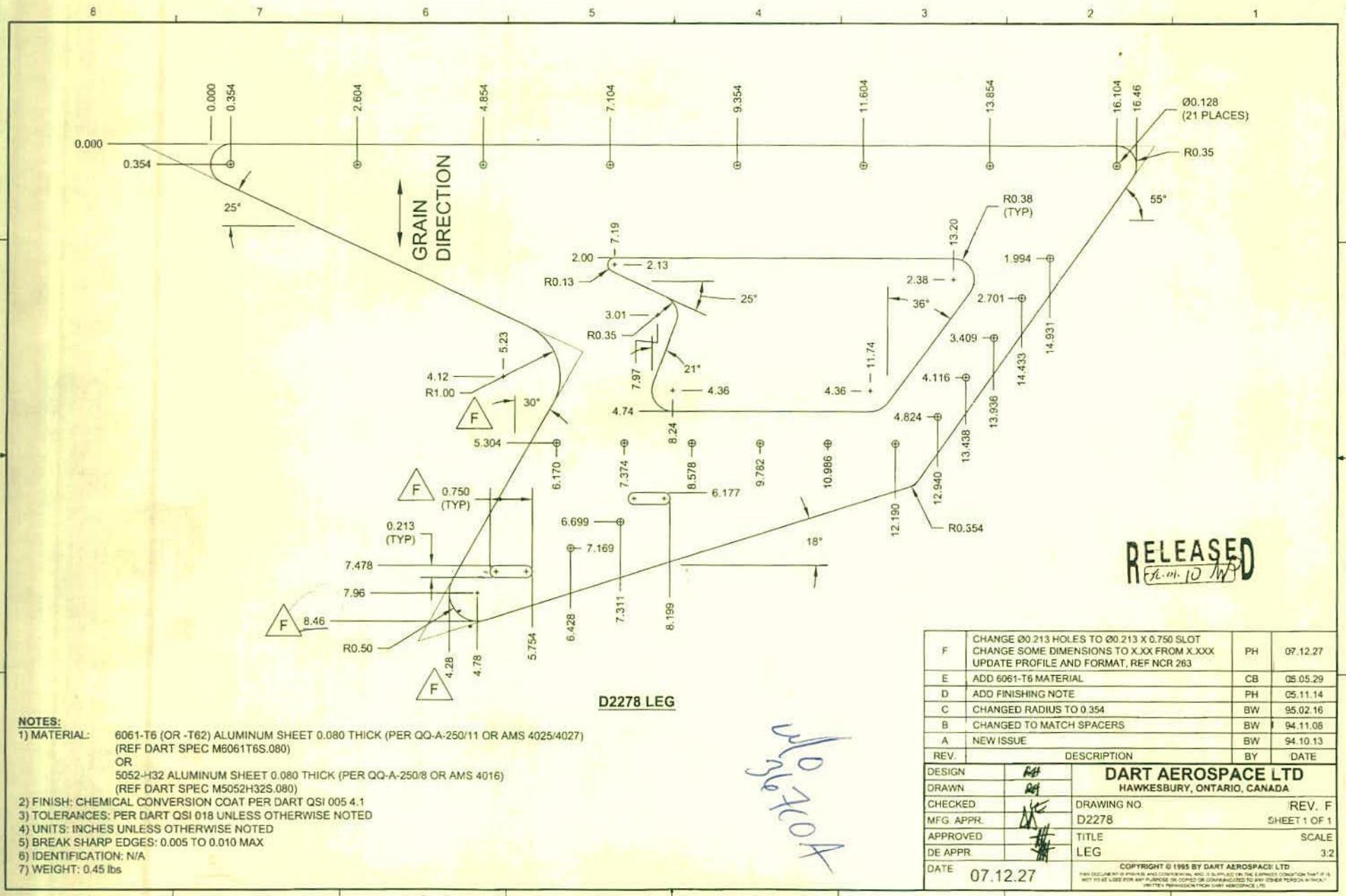
W 08.01.17

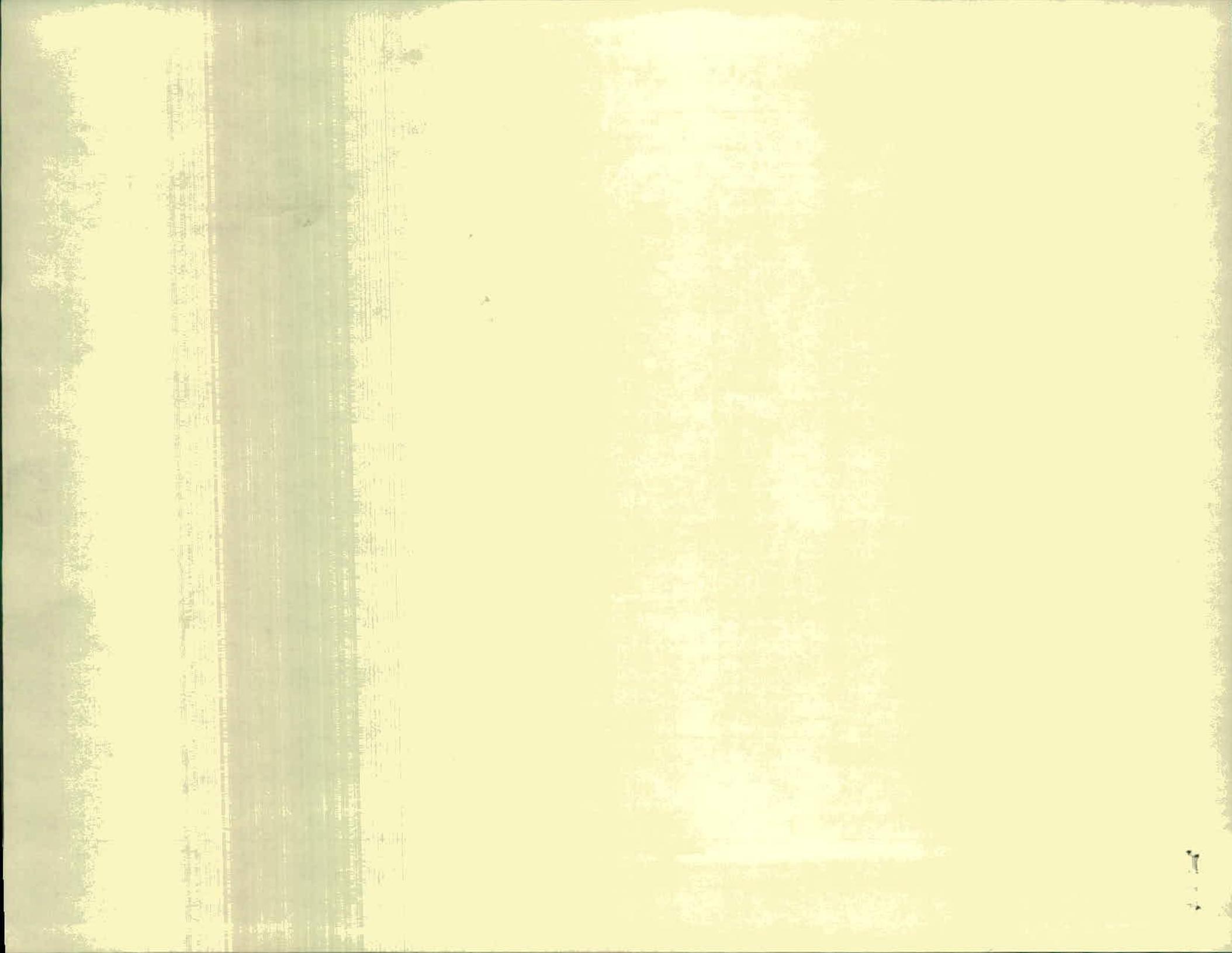
W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD

Work Order: 36710A

Description: STEP LEG

Part Number: D2278

Inspection Dwg: D2278 Rev: F

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FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.128	+.005 -.001	.131	X			
.354	-.010	.354	X			
2.604	-.010	2.604	X			
4.854	-.010	4.854	X			
7.104	-.010	7.104	X			
9.354	-.010	9.354	X			
11.604	-.010	11.604	X			
13.854	-.010	13.854	X			
16.104	-.010	16.104	X			
16.46	-.030	16.46	X			
.354	-.010	.354	X			
2.00	-.030	2.008	X			
4.74	-.030	4.748	X			
.750	-.010	.754	X			
.213	-.010	.217	X			
1.994	-.010	1.995	X			
2.701	-.010	2.701	X			
3.409	-.010	3.409	X			
4.116	-.010	4.116	X			
4.824	-.010	4.826	X			
5.304	-.010	5.304	X			
8.46	±0.030	8.45	X			

Measured by:	B
Date:	8-1-15

Audited by:	S
Date:	08/01/15

Prototype Approval:	✓
Date:	8/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

